

Work Order ID 59918

June 17, 2010 8:22:31 AM



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Item ID:	D3278-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Support					
Start Date:	18/06/2010	Start Qty:	60.00			
Required Date:	23/06/2010	Req'd Qty:	60.00			
Reference:	<i>Inv 10.06.17</i>					
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								
100		0.00							
	SHEAR								
Shear	Memo	0.00							
Shear	Cut blank: 2.00" x 1.00" x 2.550" long								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Machine as per Folio FA405 and Dwg D3278□2- Deburr and Tumble□Identify as D3278-2								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

8/10/06/17

60 *0*

Inv 10/06/19

60 *0*

Inv 10/06/19

60 *0*

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Item ID:	D3278-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Support					
Start Date:	18/06/2010	Start Qty:	60.00		Cust Item ID:	
Required Date:	23/06/2010	Req'd Qty:	60.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>10-6-22</i>						
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	<i>10/06/28</i>			<i>60</i>	<i>9</i>		
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <i>10:15</i> <i>320°</i> FINISH TIME: <i>10:45</i>	0.00 0.00	<i>M114841</i>						
						<i>60</i>	<i>13</i>	<i>10-6-28</i>	

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Item ID: D3278-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 18/06/2010 Start Qty: 60.00



Cust Item ID:

Required Date: 23/06/2010 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MA 10 06 28 (60)

170

Identify as per dwg & Stock Location: 045

0.00



Packaging

Memo

0.00

Packaging

P 10/4/28 (60)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/29

UMF

10-6-29

Picklist Print

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Work Order ID: 59918

Parent Item: D3278-2

Parent Item Name: Support



Start Date: 18/06/2010

Required Date: 23/06/2010

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: ☐A☐04.04.19☐New issue☐KJ/JLM☐
IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	32.5000	0.2337	14.76			



6061-T6 Bar 1.00 x 2.00



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	30.27	
114415	30.27	
MAT03	2.23	
112567	2.23	

14.76 8.8, 9/06/17

+ SCR9p 6 INCHES

DART AEROSPACE LTD		Work Order:	59918
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278	Rev: C	Page 1 of 1	

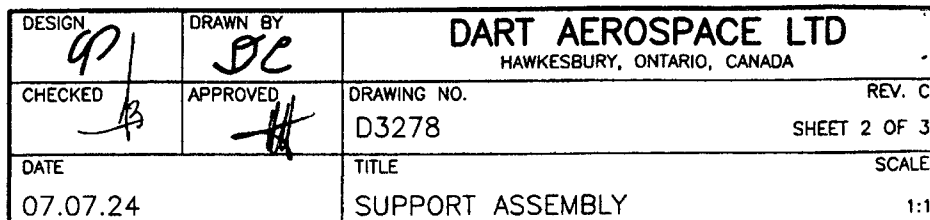
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.098	✓			
0.359	+/-0.005	.359	✓			
0.609	+/-0.010	.613	✓			
0.250	+/-0.010	.250	✓			
1.480	+/-0.005	1.480	✓			
R0.125	+/-0.010	R.125	✓			
0.119	+0.005/-0.004	.120	✓			
2.439	+/-0.010	2.440	✓			
1.980	+/-0.010	1.981	✓			
R0.13	+/-0.030	R.130	✓			
Ø0.257	+0.005/-0.000	Ø.258	✓			
R0.375	+/-0.010	R.375	✓			
0.875	+/-0.010	.873	✓			
0.500	+/-0.010	.500	✓			
R0.400	+/-0.010	R.400	✓			
R1.00	+/-0.030	R.1.00	✓			
1.720	+/-0.010	1.722	✓			
R0.125	+/-0.010	R.125	✓			
0.125	+/-0.010	.128	✓			

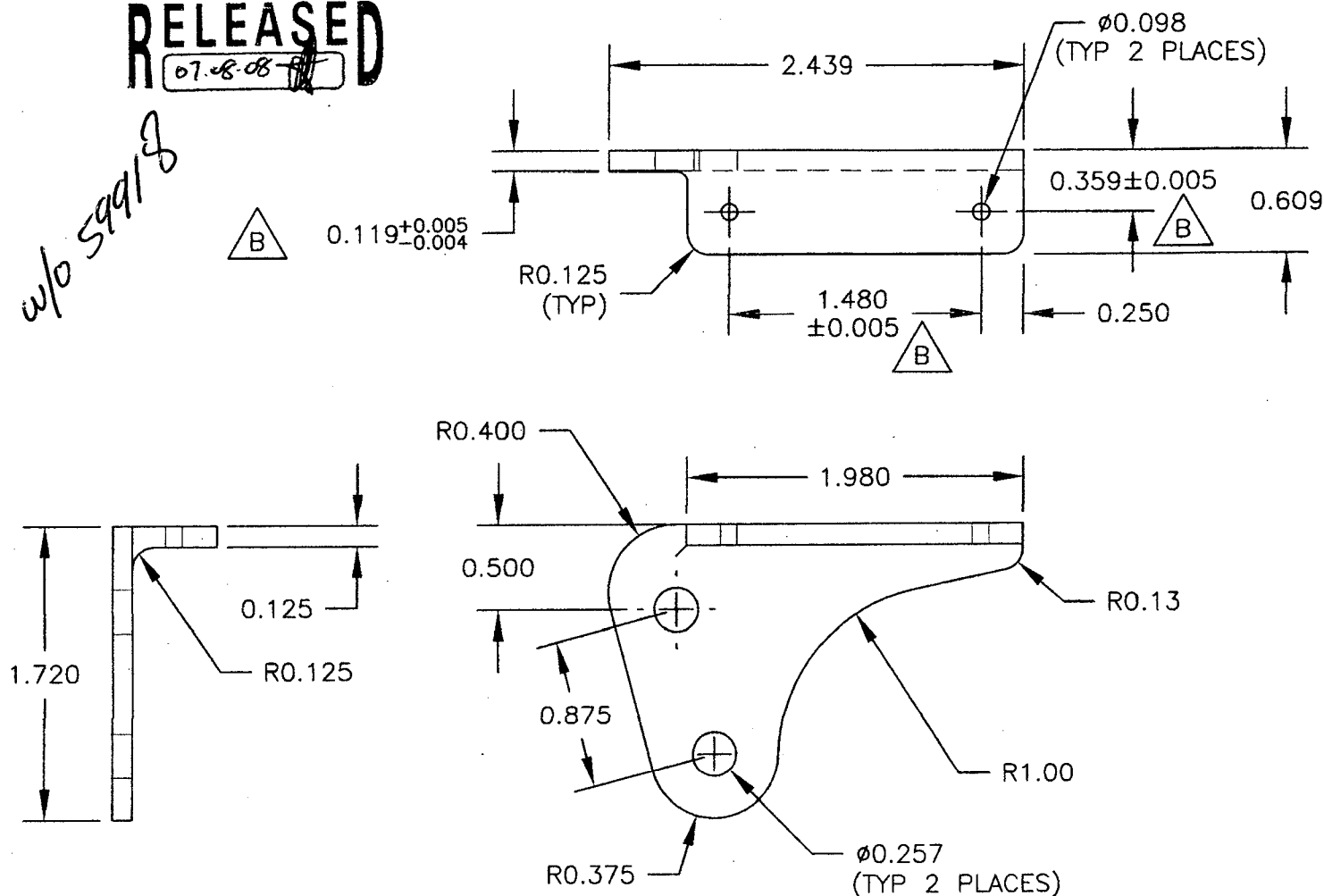
Measured by: <i>aml</i>	Audited by: <i>af</i>	Prototype Approval:	N/A
Date: 10/06/19	Date: 10-6-22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	<i>af</i>



RELEASED
07-08-08

w/o sqq/d



D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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